

Date: Monday, 11/19/2007 4:05:08 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CABIN FLOOR PROTECTOR
Job Number : 35864	
Estimate Number : 12764	
P.O. Number : <u>N/A</u>	Part Number : D35743
This Issue : 11/19/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3574 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 33396	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 12/5/2007 Qty: 3 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev : A New Issue 07-01-22 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	F60029	lexan grey
-----	--------	------------



Comment: Qty.: 32.0000 sf(s)/Unit Total : 96.0000 sf(s)

F60029 lexan sheet

Batch: 105330 HB 07-11-22

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3574

Dwg Rev: A

Prog Rev: A

HB 07-11-22

(3)

2-Deburr if necessary

SAD 02-11-24

(3)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

HB 07-11-22

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

[Signature] 12/23 (3)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

SAD 07-11-24

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/11/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 11/19/2007 4:05:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN FLOOR PROTECTOR

Job Number: 35864

Part Number: D35743

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 7/11/26 (X3)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock

Location:

35818 07/11/27 (X3)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/27 (3)

Job Completion



07/11/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

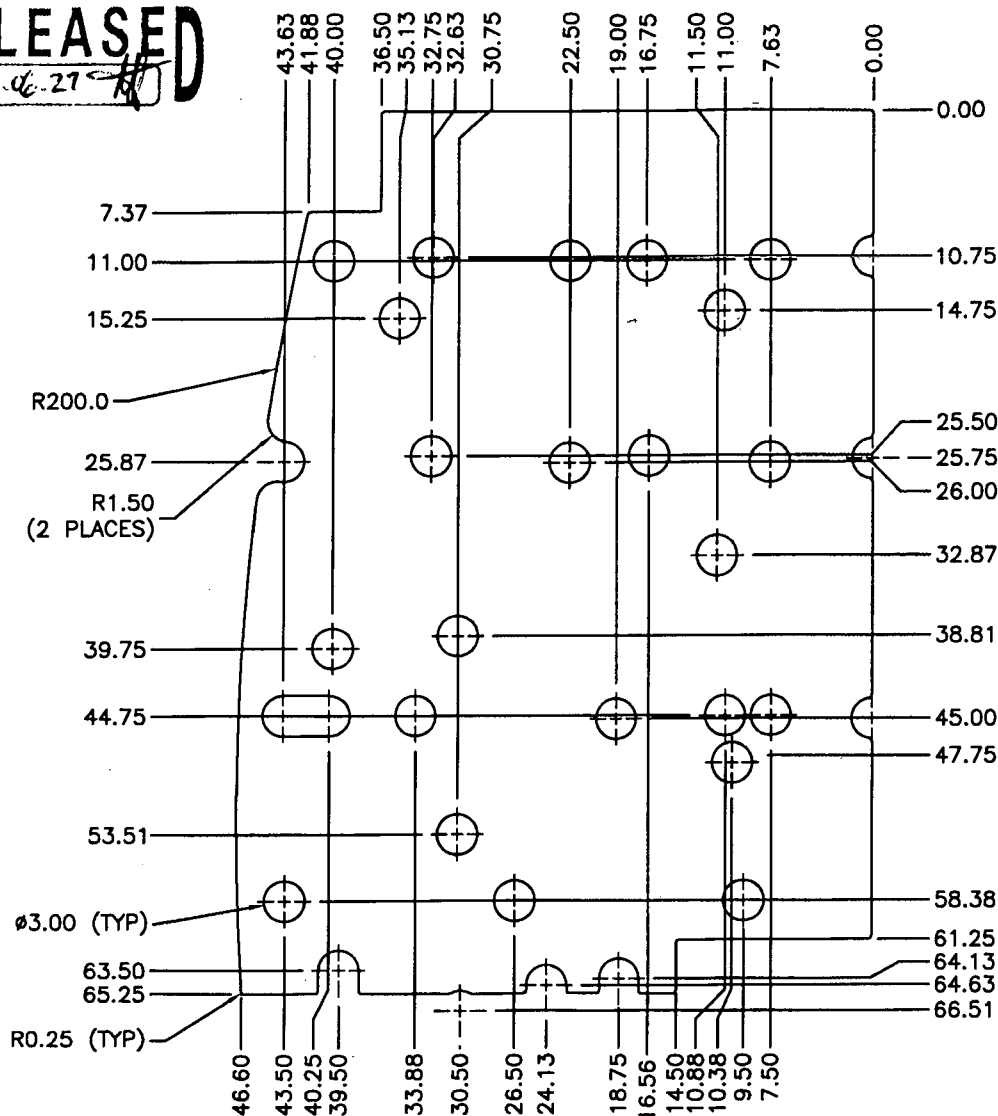
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>LE</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>H</i>	DRAWING NO. D3574	REV. A SHEET 1 OF 5
DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14
A	07.06.08	NEW ISSUE	

RELEASED
07-06-27**D3574-1 CABIN FLOOR PROTECTOR (SHOWN). D3574-2 (OPPOSITE)****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-1/-2" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8961

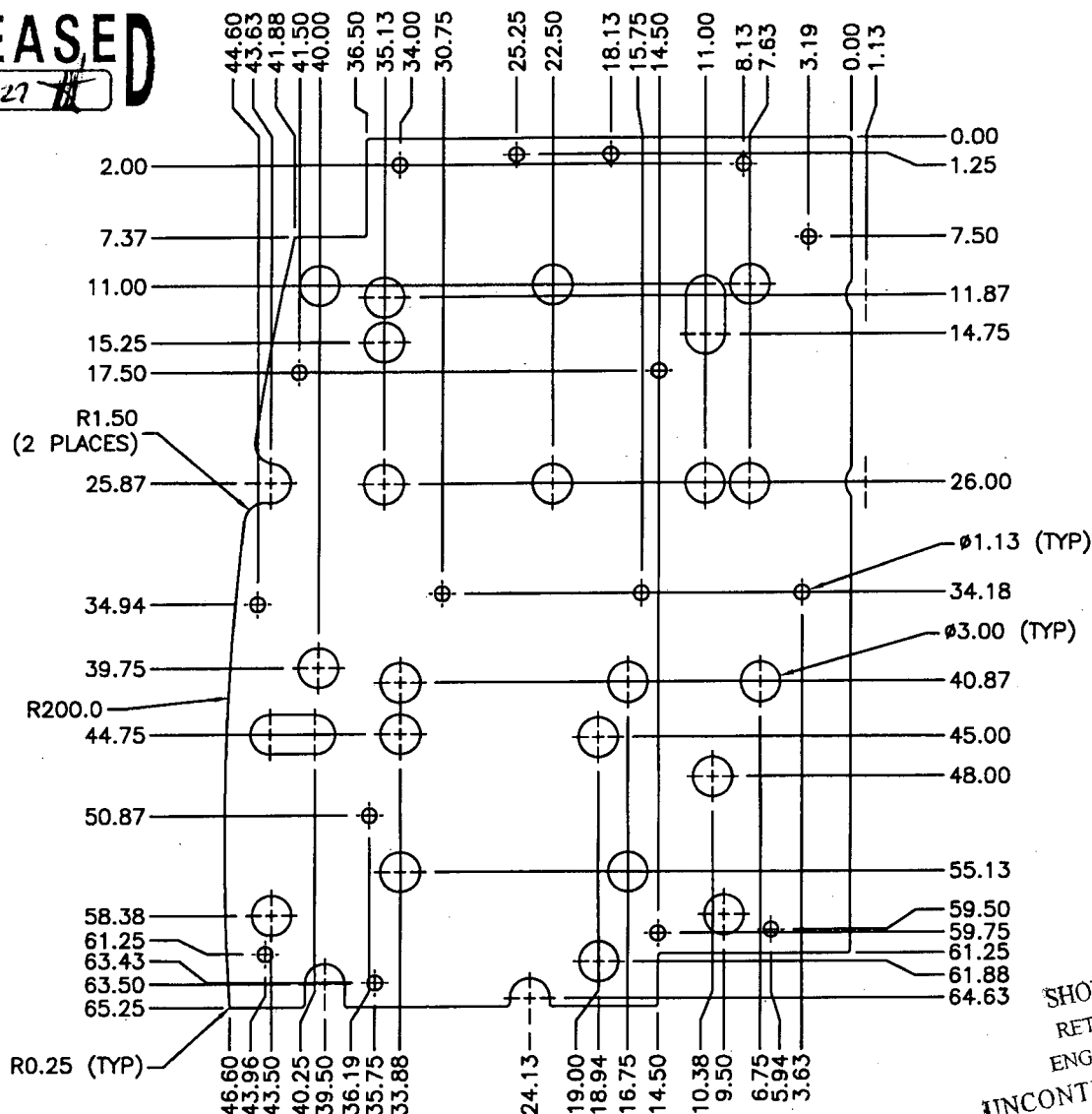
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DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:14

RELEASED
07.06.27**D3574-3 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 IN THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-3" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8962

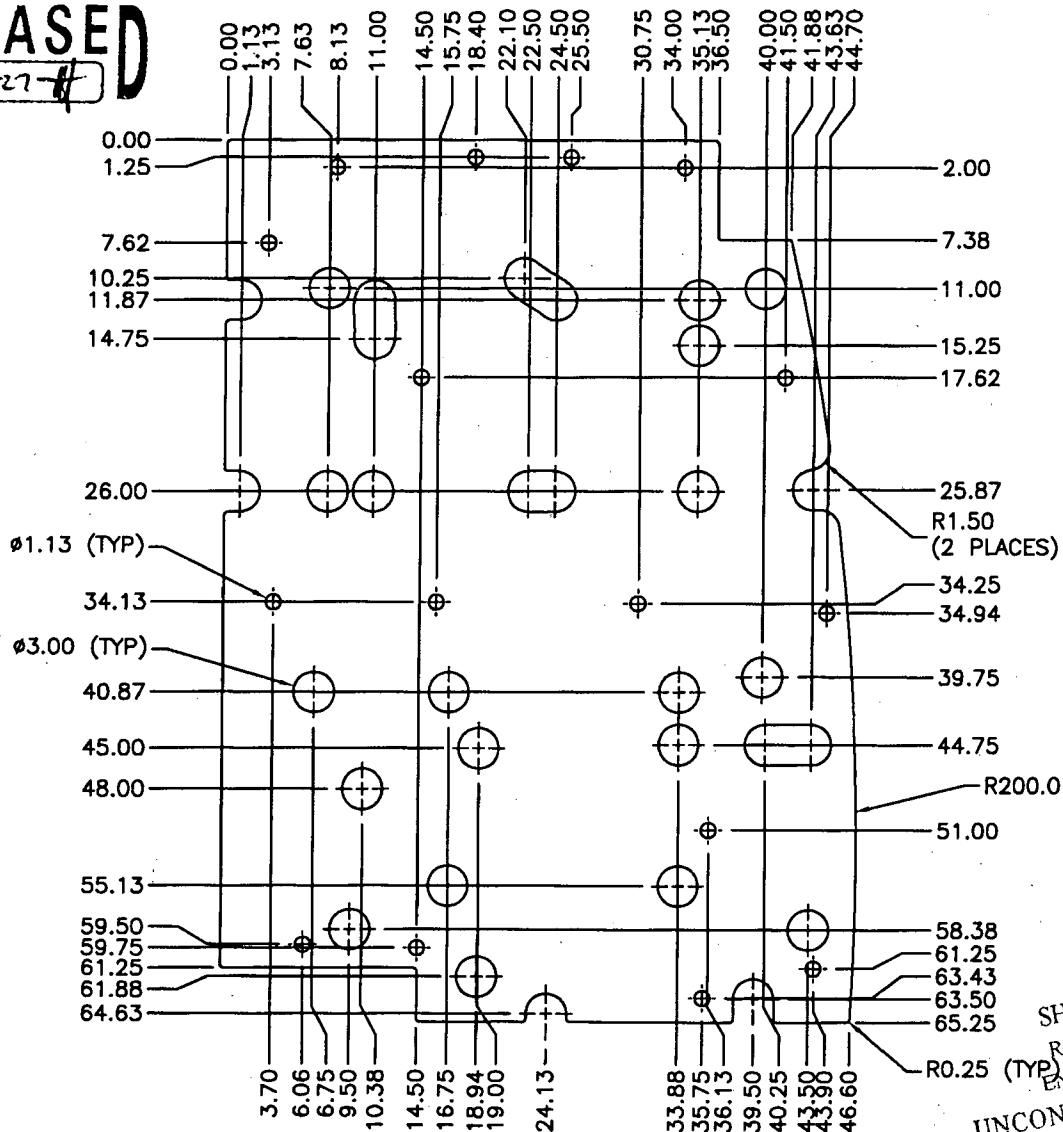
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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.27**D3574-4 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-4" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8963

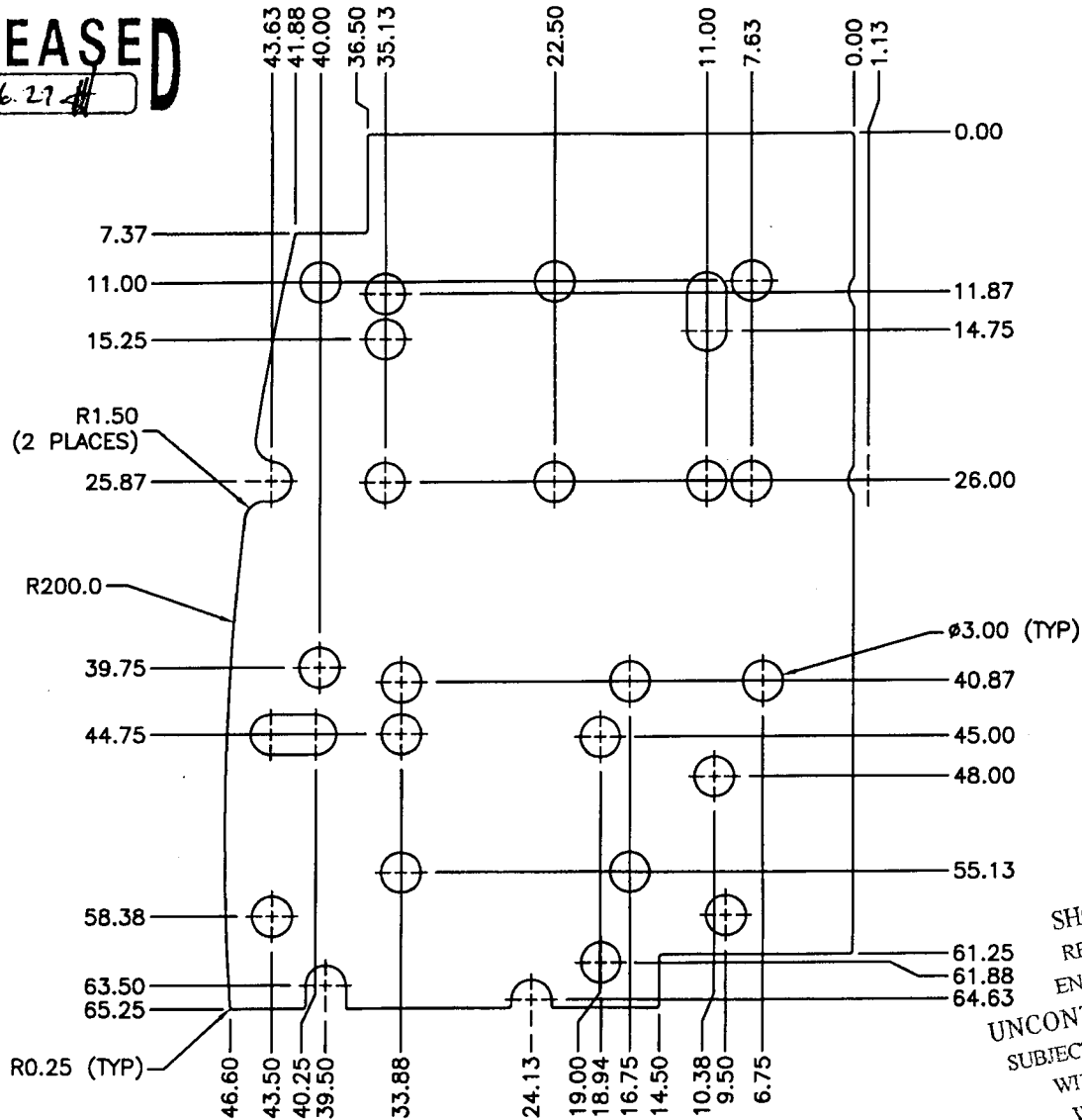
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CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3574	REV. A SHEET 4 OF 5
DATE 07.06.08	TITLE CABIN FLOOR PROTECTOR		SCALE 1:14

RELEASED
07.06.27**D3574-5 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-5" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8964

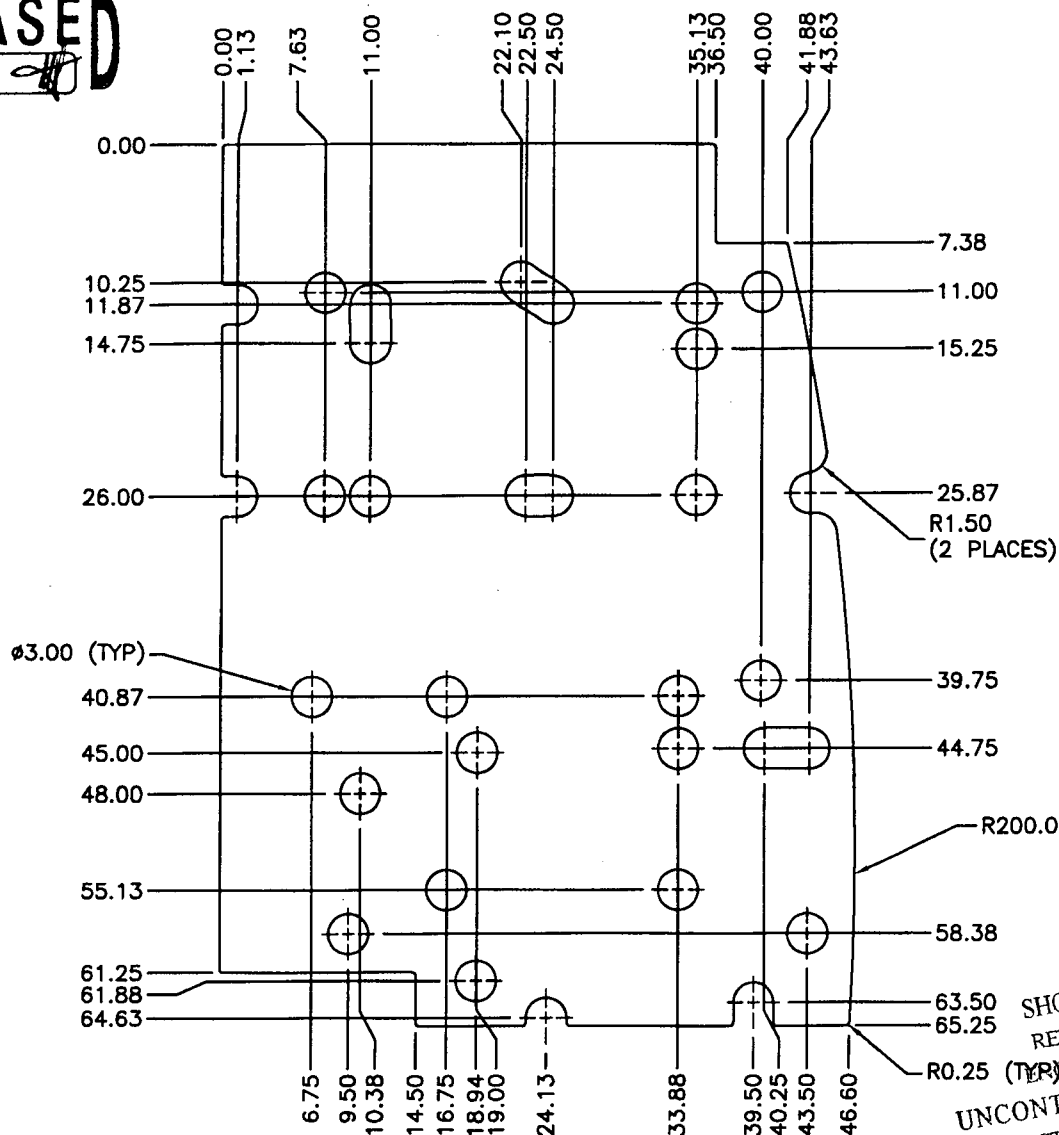
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DATE 07.06.08		TITLE CABIN FLOOR PROTECTOR	SCALE 1:14

RELEASED
07.06.27**D3574-6 CABIN FLOOR PROTECTOR****NOTES:**

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3574-6" USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE OF PART
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- 7) CHECK PER TEMPLATE DT8965

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DART AEROSPACE LTD		Work Order: 35864
Description: CABIN FLOOR PROTECTOR		Part Number: D3574-3
Inspection Dwg: D3574-3 Rev: A		Page 1 of 1


FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 1.13	+ .004 - .001	1.135	x			
Ø 3.00	+ .006 - .001	3.009	x			
2.00	+/- .030	2.00	x			
7.37	+/- .030	7.37	x			
11.00	+/- .030	11.00	x			
15.25	+/- .030	15.25	x			
17.50	+/- .030	17.50	x			
25.87	+/- .030	25.87	x			
34.94	+/- .030	34.94	x			
39.75	+/- .030	39.75	x			
44.75	+/- .030	44.75	x			
50.87	+/- .030	50.87	x			
58.38	+/- .030	58.38	x			
61.25	+/- .030	61.25	x			
63.43	+/- .030	63.43	x			
63.50	+/- .030	63.50	x			
65.25	+/- .030	65.25	x			

Measured by: RB
Date: 07-11-22

Audited by: S
Date: 07/11/23

Prototype Approval: 
Date: 11/11

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



DART AEROSPACE LTD		Work Order:	35864
Description: CABIN FLOOR PROTECTOR		Part Number:	D3574-3
Inspection Dwg: D3574- Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.19	+/- .030	3.19	*			
7.63	+/- .030	7.63	*			
8.13	+/- .030	8.13	*			
11.00	+/- .030	11.00	*			
14.50	+/- .030	14.50	*			
15.75	+/- .030	15.75	*			
18.13	+/- .030	18.13	*			
22.50	+/- .030	22.50	*			
25.25	+/- .030	25.25	*			
30.75	+/- .030	30.75	*			
34.00	+/- .030	34.00	*			
35.13	+/- .030	35.13	*			
36.50	+/- .030	36.50	2			
40.00	+/- .030	40.00	*			
41.50	+/- .030	41.80	*			
41.88	+/- .030	41.88	*			
43.63	+/- .030	43.63	2			
44.60	+/- .030	44.60	2			

Measured by: BB	Audited by: J	Prototype Approval: 2/7
Date: 07-11-22	Date: 7/14/23	Date: 7/14

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

[Handwritten signature]

DAFT AEROSPACE LTD		Work Order:	35864
Description: CABIN FLOOR PROTECTOR		Part Number:	03574-3
Inspection Dwg: 03574-3 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Prototype

[illegible]

Measured by:	B
Date:	07-11-77

Audited by:	
Date:	

Prototype Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	